

Work Order ID 135059

Monday, July 27, 2015 2:37:19 PM

135059

Ship
Aug 13th
Page 1

Item ID: D412-594-301 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Switch Provisions
 Start Date: 7/27/2015 Start Qty: 2.00 *?
 Required Date: 8/7/2015 Req'd Qty: 2.00 *?
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: *mf* Date: *15-7-27* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D205-594	E	JA

SH 15-07-30

100 0.00

100

DC DOCUMENT CONTROL 0.00
 Memo
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP
 D412-594-301 CHG001

AUG 17 2015 *2* *DAS 6 9-89*

110 Pick Kit 0.00

110

Packaging Memo 0.00
 Packaging

2 *JA* *JUL 29 2015* *DAS 27 9-89*
JUL 30 2015

120 QC4- 100% Inspect kits for completeness 0.00

120

QC Memo 0.00
 Quality Control

AUG 17 2015 *2* *DAS 6 9-89*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 7/27/2015 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 8/7/2015 **Req'd Qty:** 2.00 ***?***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

0.00

Packaging

Memo

~~AUG 17 2015~~

DAS

Packaging

Identify and pack for shipping as per PPP D412-594-301

Location: 122

6
9-88

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLK

AUG 17 2015

मि०

AUG 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 135059

135059

Parent Item: D412-594-301

D412-594-301

Parent Item Name: Switch Provisions

Start Date: 7/27/2015

Required Date: 8/7/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.08.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3189-3		Manufactured	No				Each	28.0000	1	2			
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D3189-3

Chafing Shield

DAS
6
9-89

Location

Loc Qty

Loc Code

LG053

28

79274

10

89029

3

89805

15

**

JA

DAS

27

9-89

MS21920-24

Purchased

No

Each

62.0000

4

MS21920-24

Clamp

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

2

117998

2

LG050

60

108258

1

120079

1

m129317

22

m132045

36

**

JA

JUL 29 2015

DAS

27

9-89

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

5.3 CROSSTUBE ASSEMBLIES

QTY 596 -101	QTY 596 -103	QTY 596 -105	QTY 596 -107	QTY 596 -203	Part No.	Description
X					D205-596-101	CROSSTUBE ASSEMBLY, HI HI FWD
	X				D205-596-103	CROSSTUBE ASSEMBLY, HI HI AFT
		X			D205-596-105	CROSSTUBE ASSEMBLY, HI HI FWD
			X		D205-596-107	CROSSTUBE ASSEMBLY, HI HI AFT
				X	D412-596-203	CROSSTUBE ASSEMBLY, HI HI AFT
2		2			D2893-1	SUPPORT
4		4			D3595-063-450	RUBBER CUSHION
4		4			MS21920-25	CLAMP
	2		2		D2940-1	SUPPORT
	4		4		D3595-063-530	RUBBER CUSHION
	4		4		MS21920-28	CLAMP
				1	D4909-1	SUPPORT
				2	D4910-1	CHAFING SHIELD
				2	D3595-063-530	RUBBER CUSHION
				4	MS21920-26	CLAMP
				2	MS21920-28	CLAMP

QTY 596 -101B	QTY 596 -103B	QTY 596 -105B	QTY 596 -107B	Part No.	Description
X				D205-596-101B	CROSSTUBE ASSEMBLY, HI HI FWD (214)
	X			D205-596-103B	CROSSTUBE ASSEMBLY, HI HI AFT (214)
		X		D205-596-105B	CROSSTUBE ASSEMBLY, HI HI FWD (214)
			X	D205-596-107B	CROSSTUBE ASSEMBLY, HI HI AFT (214)
2		2		D2893-1	SUPPORT
4		4		D3595-063-450	RUBBER CUSHION
4		4		MS21920-25	CLAMP
	2		2	D2940-1	SUPPORT
	4		4	D3595-063-530	RUBBER CUSHION
	4		4	MS21920-28	CLAMP

5.4 SWITCH PROVISIONS KIT

QTY -301	Part Number	Description
X	D412-594-301	SWITCH PROVISIONS KIT
1	D3189-3	CHAFING SHIELD
2	MS21920-24	CLAMP (OR MS21920-23)